

20-7992



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3043-042
Job Sheet 205639



Part No: D3043-042

Job Qty: 5 pcs

Part Name: Step Weldment RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/20

Job Tracking No:

Due Date: 4/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	5 pcs			0.00	1.25	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 5	5 pcs			0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



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Container No: S249971



Part: D3043-042

Job No: 205639

Serial No/Batch: S249971

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/23/20

Plex 1/15/20 8:38 AM Dart.lajeunesse.marie

P.T.O.

120 Large Fab - Steps - 2 - B4B	5 pcs	0.00 3.33 17k	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	Adm. 8-14
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
130 QC 9	5 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	DAS
			QC 9 - 50	43
			QC 9 - 9	9-89
140 QC 5	5 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	DAS
			QC 5 - 49	43
			QC 5 - 51	9-89
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
150 Handfinish - 1-1 Chemical- B4B	5 pcs	0.00 0.83	Handfinish - 1 - 1 - B4B	BEB 20-02-07 07.
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	

			Packaging 3 - 24 - B4B	DAS
			Packaging 3 - 25 - B4B	72
			Packaging 3 - 26 - B4B	9-89
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
250 QC 21 - SA	5 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	

FEB 28 2020

Part Op 100 - Fabricate per Drwg) 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup
 Descriptions: DT8185-G 2-Debur and bevel ends for welding

110 - (QC6- All purchased or subcontracted products)

120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808 AR AL ROD

Batch 7139012 2-Grind Fwd End Cap weld flush

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (Fabricate per Drwg) 1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: 7139012 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Touch up alodine)

210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-START Time: 10:20 OVEN TEMPERATURE: 320°

220 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

230 - QC3- Inspect Part Finish)

240 - Identify as per dwg & Stock Location: _____

250 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	5 pcs (1 ea)	100-Large Fab - Steps - 1	5243427
D2734	Step End Plate	10 pcs (2 ea)	100-Large Fab - Steps - 1	5242135
D3040-1	Mounting Lug	10 pcs (2 ea)	100-Large Fab - Steps - 1	5242980
D3040-3	Mounting Lug	10 pcs (2 ea)	100-Large Fab - Steps - 1	5242990

Job Allocations

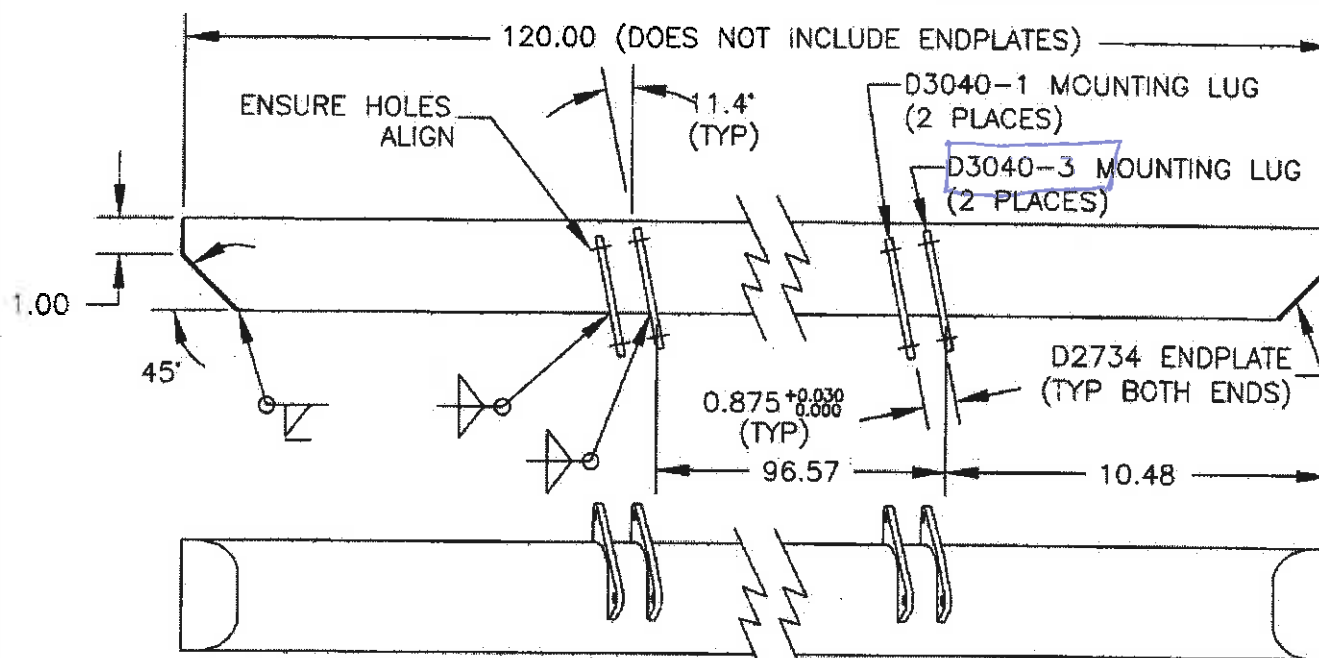
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	5	160	0
	D2734	10	44	0
	D3040-1	10	12	0
	D3040-3	10	12	0

Part Specifications

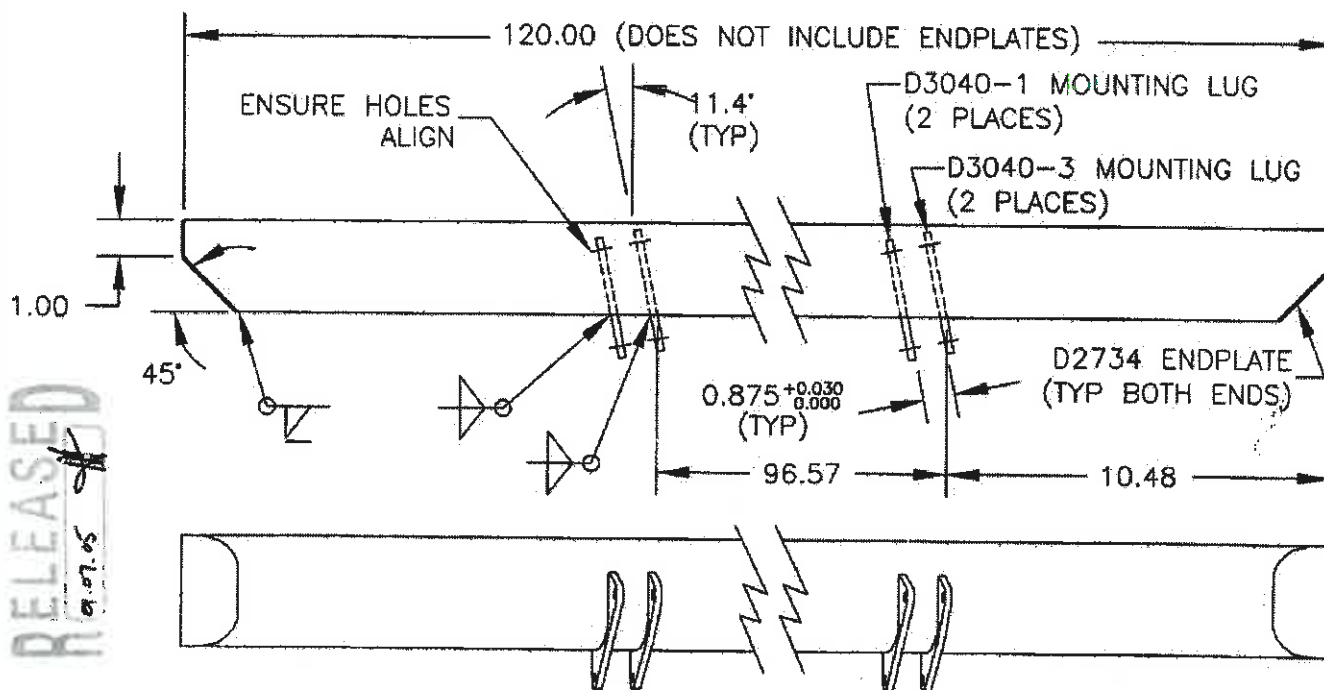
Specifications could not be found.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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Entered: 2R Date: Mar 5/2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-7992

Route update only ☐

Job: <u>S24997T</u> <u>D3043-042</u> Part No. <u>D3043-042</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Date : le 6 Fevrier 2020 Sequence #: 130 QTY Affected : ① MRB (QSI042) DAS 9 20-02-06

Description Work Order Deviation	Disposition	Completed By
- Lug D3040-3 is welded @ .137" over tolerance.	Scrap destroy + no replace qty 1 of D3043-042	<u>[Signature]</u> Lead hand / Supervisor <u>DAS 43 9-89</u> QC / QA Coordinator <u>DAS 9 9-89 20-02-06</u>

Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																													